

NUT FORMERS

CNF



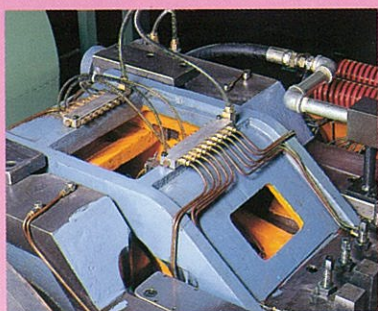
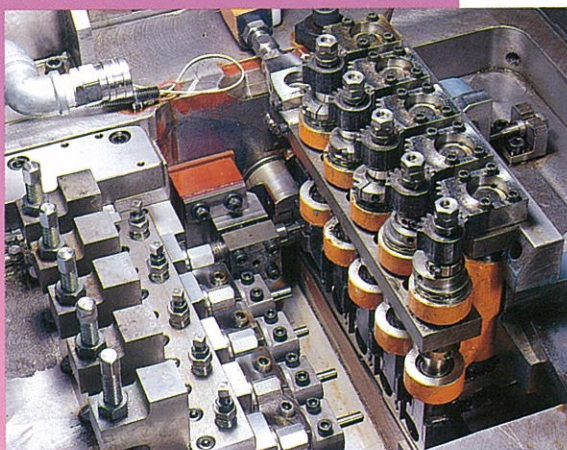
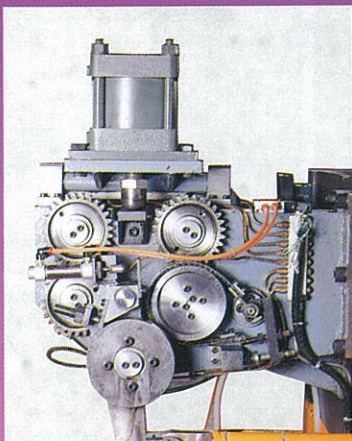
春日機械
CHUN ZU



ISO 9001

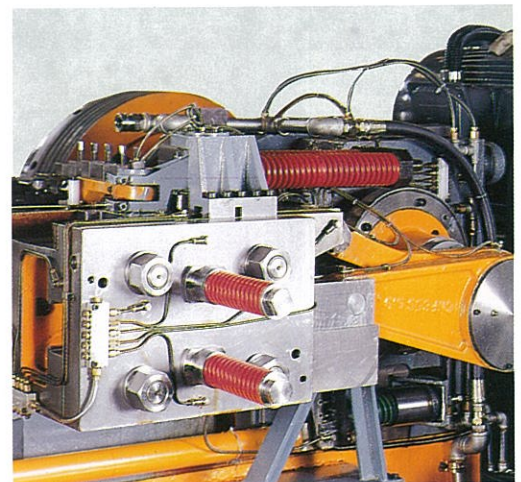
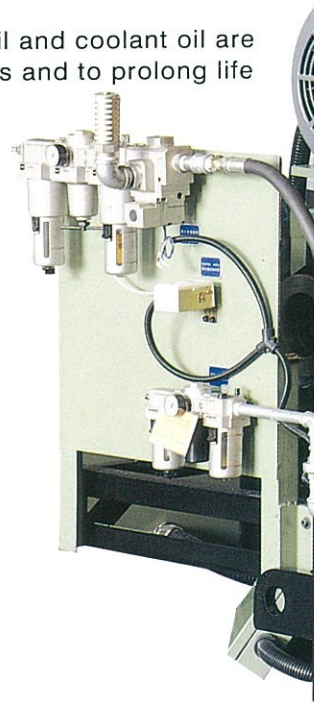
CNF

NUT FORMERS



MAIN FEATURES OF CNF:

1. Close type cut-off mechanism is adapted to assure square and clean cut-off surface. The device of material feeding stopper and material short feeding detecting assure the dimensional accuracy of blanks.
2. The design of centering adjustment between punch and die is so simple that an unexperienced operator may easily complete it in a short time and the four way adjustment of each punch holder is completely independent from one another.
3. Forming die is designed to be solid round shape to balance forging strength. This design also saves cost of tools.
4. Over arm mechanism is adapted to the main slide and main slide liner is of tool alloy steel to assure stability and precision of persistent motion.
5. The feed roller and ratchet feeding pawl are driven by pneumatic cylinder to assure automatic, power saving and quick operation. feeding and non-feeding are controlled by the ratchet Feeding pawl in order to prevent material from reversible motion.
6. Total filtering systems of lubrication oil and coolant oil are adapted to reduce chips in the oil lines and to prolong life of the machine.

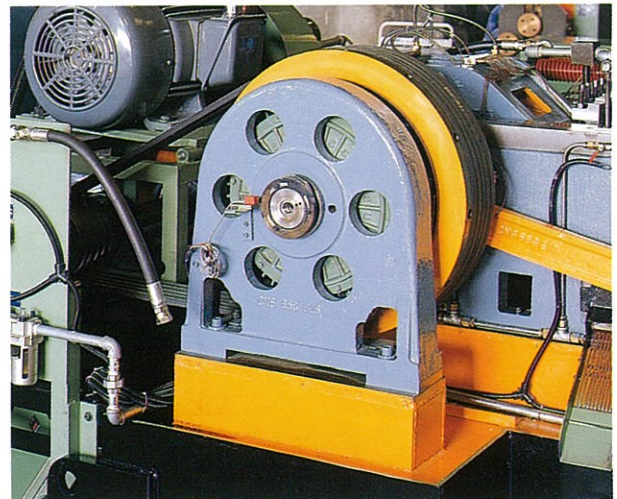
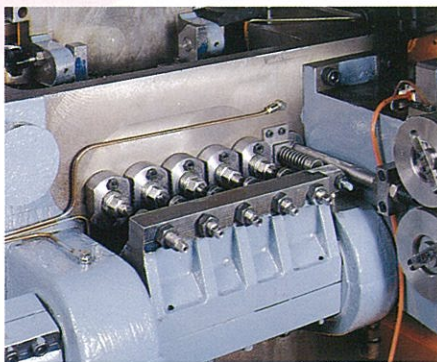
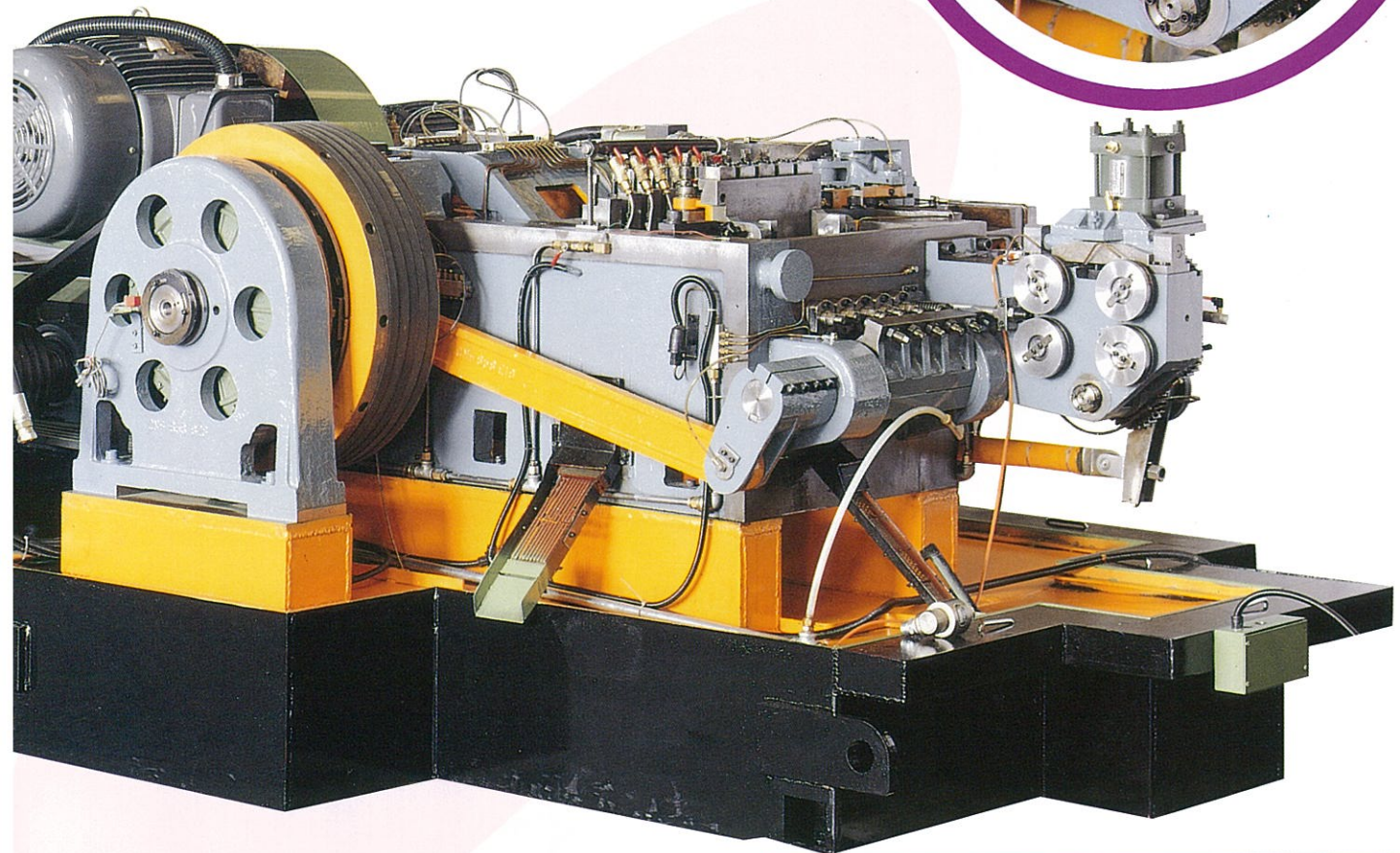
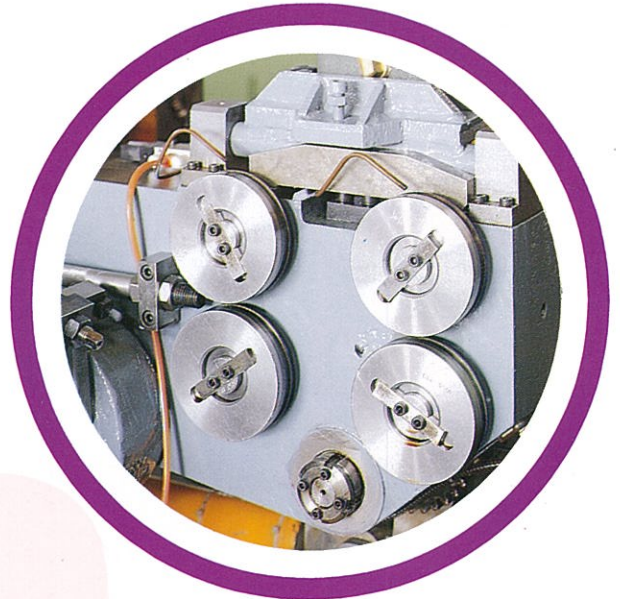


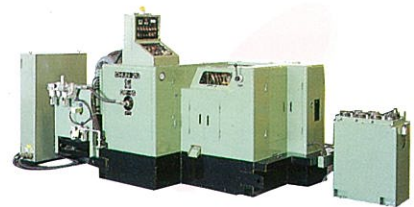
7. Air brake clutch system is adapted to allow machine start at low electric current and perform "INCHING", "ONE-STROKE" and "RUNNING" motions without affecting electric parts and motor. Except for inching, machine can always stop at the position with the main slide at its rear end position so that die area is maximized for working onto the punches and dies. The machine is also able to operate forward inching, backward inching and testing.

8. Auto checker will check out all under functions :

- 1) . Out-put speed
- 2) . Main motor overload
- 3) . Short feeding
- 4) . Material end
- 5) . Counter setting number
- 6) . Lubrication oil pressure too low
- 7) . Air pressure too low

During operation, when any of the above listed functions happens, the machine will stop and pilot light will be on to the operator to check and eliminate problem for running.





SPECIFICATION OF NUT FORMERS :

M/C TYPE		CNF-65S	CNF-65L	CNF-85S	CNF-85L	CNF-105S	CNF-105L	CNF-145S	CNF-145SM	CNF-165S	CNF-165L	CNF-20SM
Description												
NO. OF FORGING STATION		5	5	5	5	5	5	5	5	5	5	5
FORGING LOAD	Kg	52,000	52,000	70,000	70,000	105,000	105,000	190,000	190,000	260,000	260,000	400,000
MAX. CUT-OFF DIA.	mm	φ 10	φ 10	φ 14	φ 14	φ 17	φ 17	φ 22	φ 22	φ 26	φ 26	φ 32
MAX. CUT-OFF LENGTH	mm	8	15	12	20	14	21	17	21	25	40	35
MAX. OUT PUT	pcs/min.	300	200	230	150	190	125	150	120	120	100	100
K.O. STROKE	mm	11	35	16	40	20	38	24	54	55	80	45
MAIN SLIDE	mm	70	100	84	120	100	130	134	160	160	230	160
MAIN MOTOR	HP	15	20	20	25	30	40	40	50	75	75	100
CUT-OFF DIE DIA.	mm	φ 40	φ 40	φ 50	φ 50	φ 60	φ 60	φ 80	φ 80	φ 89	φ 89	φ 92
PUNCH DIA.	mm	φ 35	φ 35	φ 50	φ 50	φ 60	φ 60	φ 75	φ 75	φ 85	φ 85	φ 90
MAIN DIE DIA.	mm	φ 50	φ 50	φ 60	φ 60	φ 75	φ 75	φ 100	φ 100	φ 118	φ 118	φ 143
DIE PITCH	mm	58	58	70	70	84	84	108	108	129	129	148
MACHINE NET WT.(APPROX.)	Kg	7,800	8,500	8,500	10,000	16,000	16,500	26,000	28,000	42,000	42,000	45,000
ACROSS SIZE OF HEX NUT	mm	11	11	13	13	17	17	22	22	26	26	32

Remarks:

- 1.The material of cut-off and forming shown above are for low/medium carbon steel and high tensile alloy steel (GRADE 10.8)
- 2.Minimum nut size for all machines can be discussed on request.
- 3.All machines are equipped with air clutch brake of 5.5-6.0 kg/cm² air pressure.
- 4.All machines are equipped with automatic circular lubricating system.
- 5.The maximum speed of out-put for stainless steel parts and special trial should be discussed in advance.
- 6.Modifications subjected to change without any notice.

Our Allied Products:

- Bolt Formers
- Parts Former
- 2 die - 2 Blow Heading Machine
- Heading Machine
- Open Die Header
- Thread Rolling Machine
- Slotting Machine
- Forming Tools
- Thread Rolling Die
- Trimming Die



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